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D5101-3
Job Sheet 199229

Part No: D5101-3		Job Qty: 24 pcs
Part Name: Insert		
Part Weight: 0 lbs	Status: New	Priority: Medium
Job Created: 8/15/19	Job Tracking No:	
Due Date: 9/6/19	Created By: Marie Lajeunesse	
Type: Stock	Description:	
Note: DWG REV C SHEET 3 IPP REV:A NEW ISSUE 14-12-18 JLM VERIFIED BY:DD		
Ship Via:		

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	24 pcs		9/6/19	1.00	2.31	Doosan - 1		19/08/24
120	QC 8	24 pcs		9/6/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		19-08-25
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Handfinish - 1-1 Chemical-B4B	24 pcs		9/6/19	0.00	0.17	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		AUG 26 2019
							Handfinish - 1 - 4 - B4B		

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65
9-89

					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 QC 7	24 pcs	9/6/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	

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40
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160 Packaging 3-2 - Stock - B4B	24 pcs	9/6/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	24 pcs	9/6/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Doosan Lathe)TURN AS PER FOLIO FB 357

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - v(Cheical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - (Identify as per dwg & Stock Location:)

170 - (QC21- Final Inspection - Work Order Release)

FPOO1

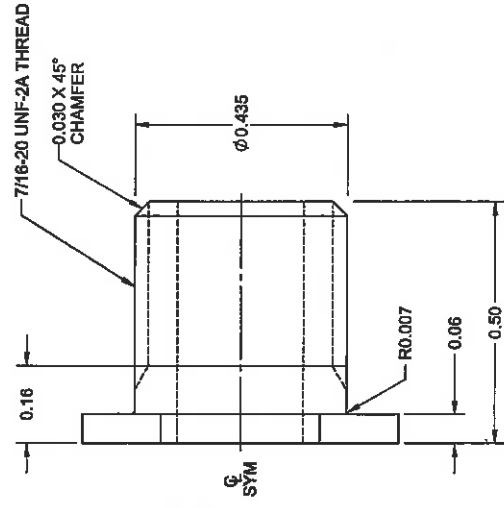
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.750	6061-T6 Round Bar .750"	2.0880 ft (.087 ea)	100-Doosan - 1	S15076

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M6061T6R0.750	2	14	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Insert	0.257inches	+ 0.006 - 0.001	0.263 0.256	
2	Insert	0.563inches	± 0.010	0.573 0.553	
3	Insert	0.160inches	± 0.030	0.190 0.130	
4	Insert	0.500inches	± 0.030	0.530 0.470	
5	Insert	0.060inches	± 0.030	0.090 0.030	

Plex 8/15/19 8:26 AM Dart.lajeunesse.marie

Job: _____		DISPOSITION		DEPARTMENT/PROCESS			
Part No. _____		Rework Scrap Use-as-is		Cross tube Small Fab Finishing			
				Skid-tube Machining Large Fab			
Date :		Sequence #:		QTY Affected :		MRB (QS1042)	
Description Work Order Deviation				Disposition			
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			
Completed By				Lead hand / Supervisor			
QC / QA Coordinator							



RELEASED
2016-11-01
APPROVED

DESIGN	AK	DART AEROSPACE USA, INC.		REV. C	SHEET 3 OF 6	SCALE	NTS
DRAWN	AJS	EUGENE, OR		DRAWING NO.			
CHECKED	WM			D5101			
MFG. APPR.	JLM			TITLE			
APPROVED	WM			CROSSBOLT SPACER			
DE APPR.	DS						
DATE	16.04.19			CONFIRMED FOR DART AEROSPACE USA, INC. THE SIGNATURES AND INITIALS AND DATE ON THIS DRAWING OR PART IF IT IS USED FOR PURCHASE OR CONSTRUCTION OF A PART OR FOR THE PART IT IS NOT TO BE USED FOR ANY PURPOSES OUTSIDE OF THE ABOVE DESCRIBED PARTS			